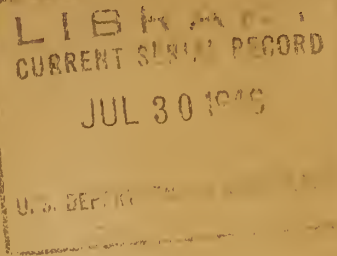


Historic, Archive Document

Do not assume content reflects current scientific knowledge, policies, or practices.

1.9422
DSC 41
Review

UNITED STATES DEPARTMENT OF AGRICULTURE
Production and Marketing Administration
Washington 25, D. C.



December 10, 1945

CHEESE (PROCESS) GRADERS MEMORANDUM NO. 20

To: Cheese Graders and Supervisors of Processing and Packaging of American Cheddar Cheese

From: B. J. Ormodt, Senior Marketing Specialist, Dairy and Poultry Inspection and Grading Division

Subject: Procedure to be Followed in the Grading of Natural Cheese and in Supervising the Processing, Packaging, Grading and Weighing of Process Cheese to Apply on CCC Contracts

The instructions contained herein shall supersede all previous instructions and shall be fully adhered to in order to maintain uniformity in procedure.

A. NATURAL CHEESE:

1. The natural cheese shall be graded for quality and condition by examining representative samples of each vat of cheese used in the blend. The cheese accepted for blending shall not have a pronounced unclean, bitter, sour, rancid, fruity, fermented, moldy, yeasty, or any other offensive flavor.
2. The natural cheese when ready for grinding shall have been properly cleaned and be free from impurities, free from mold, rind rot or cheese pests, and shall meet age requirements as stated in the announcement.
3. Prior to grinding, the cheese shall be properly tempered, preferably by storing at 70 to 75 degrees for a period of 48 hours or longer, if necessary, in order to have all cheese at a uniformly high temperature.
4. The grader shall record on cheese graders memo the grading of the natural cheese, listing the lot and factory number, date and vat, number of cheeses in each vat, and the U. S. grade, unless the cheese to be processed is "lined-up" the previous day in groups so that the supervisor can check the "line-up" by grading sufficient groups before cleaning to determine quality. No certificate shall be issued covering the grading of the bulk cheese unless rejections are excessive, in which case a certificate may be issued for the account of the vendor.

B. SAMPLING:

1. Generally deliveries should be maximum carlots of 50,000 pounds each. A USDA lot number shall be assigned to each carlot, subdividing each carlot into six equal sublots. One 6 to 8-ounce composite sample of the process cheese shall be taken for each subplot. The 6 or 8-ounce samples shall be made up by taking equal portions at two different intervals during the production of each subplot. The samples thus composited shall be identified with USDA lot and subplot number, date of manufacture, name and address of vendor, and properly packed to avoid breakage and directed to the USDA laboratory for fat and moisture analysis.
2. Duplicate reserve samples shall be taken from each subplot and kept under seal at the plant until the laboratory results of the original sample are known. In case of breakage, the reserve sample will be used. In case of request from vendor for a retest due to high moisture or low fat of the original sample, the reserve sample will be tested. In such instances, the test of the reserve sample will be final.
3. Unless adequate facilities are available for keeping reserve samples under lock and key such samples shall be sealed by enclosing samples in fibre carton and sealing with gum tape. The supervisor shall sign his name across the tape in such a way that it will extend across the tape and container.

C. WEIGHING:

1. Test weights of the process cheese shall be obtained by weighing at least 3% of the net weight in the carlot. Cases may be weighed in groups of five or 10, depending on the size of cases and scales. Tare of cases and containers shall be established by weighing a sufficient number of cases and containers to establish a true representative tare weight.
2. In case cheese is packed in tin cans or if an equitable tare of cases cannot be established, either test weigh before placing in cases or remove cans from cases for weighing in same quantities as indicated above, establishing tare on same basis as indicated in 1 above.
3. Care should be exercised to see that test weights are made from time to time throughout the day in order to assure representative samples of the lots.

D. PROCESS CHEESE - Sampling - Grading:

1. Samples of the process cheese shall be selected from the production line for grading. In case product is uniform in quality only one sample need be examined from each subplot in a carlot. In case uniformity of the product cannot be maintained, a sample should be taken from each batch and graded for quality.
2. Samples shall be graded on the following basis, in accordance with specifications of the purchase announcement:

Flavor - Shall be fairly pleasing and have characteristics of mild to medium cured American cheddar cheese. Definitely bitter or emulsifier flavors not permitted.

Body and texture - Shall be smooth, medium firm, and resilient; practically free from openings except those caused by trapped steam. Shall be close and free from lumps or graininess; show free slice, not more than slight brittleness; the cheese shall not stick to the knife or break when cutting.

Color - The color shall be a uniform medium yellow.

3. Temperature of samples when grading shall be approximately 70°F. and shall be at least 24 hours and preferably 48 hours old at time of grading.
4. In case samples from any subplot fail to meet the requirements as outlined above, such lots shall be rejected as not meeting the contract specifications. Supervisory costs in connection with such rejected lots shall be for the account of the vendor.

E. KEEPING QUALITY SAMPLES & SAMPLES WASHINGTON OFFICE:

1. One sample from each carlot of the processed cheese shall be set aside for keeping quality test and held at ordinary room temperature (70° to 80°) for a period of six months.
2. Record of the keeping quality samples shall be kept showing:
 - (a) initial quality, and
 - (b) condition and quality at the end of six months period.
3. The Washington office shall be furnished with a record showing results of keeping quality tests immediately following final examination.

4. A one or 2# sample of process cheese shall be forwarded to the Washington office from each processing plant per week. These samples should be taken from production line and forwarded as soon as properly chilled.

F. PACKAGING, PACKING, AND MARKING:

1. Grader shall see that product is properly packed and marked in accordance with contract packaging specifications.
2. In addition, each carlot shall be assigned a USDA lot number. The cases shall be properly stamped with the assigned lot number which shall include a letter designation for each subplot such as USDA 100-A, 100-B, etc.

G. CERTIFICATE:

1. Certificate covering each carlot of process cheese should be prepared in original and five copies distributed as follows: Original and two copies to vendor, one copy to Washington office, one copy to supervisor of cheese grading in your area, and retain one copy in office file.

H. BILLING:

1. The vendor will be the applicant and will be billed by the office rendering the service on a time basis plus subsistence and transportation, if any, incurred by the grader. The laboratory will bill and collect for the analysis of the samples for moisture and fat.